

Work Order ID 75882

November-01-11 1:09:10 PM

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Page 1

Item ID: D350-591-121

Revision ID:

Item Name: Heli-Access-Step, LH

Start Date: 01/11/2011 Start Qty: 4.00

Required Date: 15/11/2011 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: M.L.J Date: 11/11/01 Tooling:

QC: Date: SPC (Y/N):

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2351	Rev E

100

0.00

100

DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

110

0.00

110

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

SHIP ASAP
Split #2

*4*3
*4*3

JB 5/12/11

11-11-09

4 0

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Item ID: D350-591-121

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step, LH

Start Date: 01/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

Memo

Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.

0.00

0.00

DP 12-6-25 (4)

130

130

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

(4) 12-06-25

140

140

Large Fab

Large Fab

Large Fab

Memo

1-Bevel Fwd and Aft end for welding

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/RAluminum Rod *22/30*

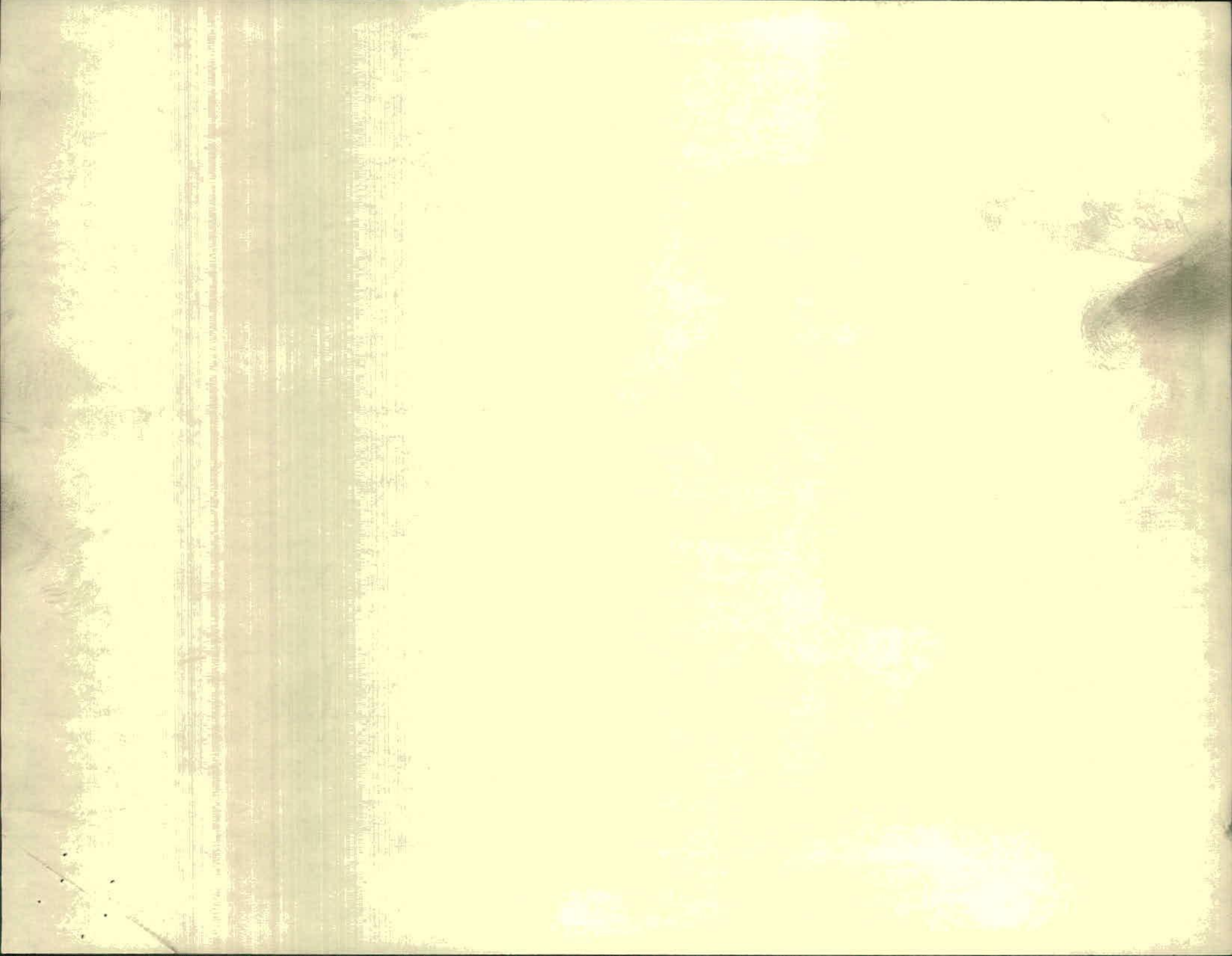
3-Do not Grind Flush

0.00

0.00

3 12-07-04

1760



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Page 3

Item ID: D350-591-121

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access-Step, LH

Stop ***NS2***

Start Date: 01/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

3 0 SEP 26 7/05

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8 12/6/06

+3

24

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

3 26 12-79

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Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 01/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0.00

180

0.00

3x \emptyset — $\frac{111x}{12/07/09}$

0.00

190

0.00

1-Rivet Leg Assembly as per Dwg D2351

2-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R Aluminum Rod 120854

3-Grind end cap flush per dwg D2351

QC10- Inspect visual per QSI004- ground welds

0.00

220

Memo

0.00

Quality Control

Solution

+3
45

~~3 4 14~~
12-07-09

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Item ID: D350-591-121

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, LH

Start Date: 01/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							
230									
QC	Memo	0.00							
Quality Control									
240	Chemical Conversion Coat per QSI005 4.1	0.00							
240									
HandFinish	Memo	0.00							
Hand Finishing									
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
250									
Powdercoat	Memo	0.00							
Powder Coating									

m121841

START TIME:
OVEN TEMPERATURE:
FINISH TIME:

8-30
320 °F
9-00

3X4
12/07/11

Work Order ID 75882

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Item ID: D350-591-121

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, LH

Start Date: 01/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

260

Wing Walk as per dwg QSI005 4.4 Batch 122320 0.00

0.00

260

HandFinish

Memo

Hand Finishing

3

φ

BR 12711

270

QC3- Inspect Part Finish

0.00

270

QC

Memo

Quality Control

3

✗

29

12/07/11

280

Pick Kit

0.00

280

Packaging

Memo

Packaging

371

✗

12/07/11 JB

Work Order ID 75882

75882

Page 7

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Item ID: D350-591-121

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, LH

Start Date: 01/11/2011 Start Qty: 4.00

4

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

290

QC4- 100% Inspect kits for completeness

0.00

Scrub

290

QC

Memo

0.00

Quality Control

300

Packaging

0.00

300

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-591-121

Location:

PPP Rev:

SHIP

310

QC21- Final Inspection - Work Order Release

0.00

310

QC

Memo

0.00

Quality Control

12/2/11 (5)

Picklist Print

Wednesday, November 09, 2011 11:12:32

Page 1

Work Order ID: 75882

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 11/1/2011

Required Date: 11/15/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3-37A

Bolt

Purchased

No

Each 2,072.0000

8

Location

Loc Qty

Loc Code

ST353

68

111668

1

118628

67

ST354

4

117619

4

ST518

2000

119086

2000

Each 1,291.0000

12

Location

Loc Qty

Loc Code

ST357

1291

118078

283

113706

8

118838

500

119449

500

Each 98.0000

8

Location

Loc Qty

Loc Code

ST358

98

117872

48

118838

50

Each 0.0000

16

AN960JD10

Washer

NAS1149D0363J Purchased

No

Each 0.0000

24

AN960JD416

Washer

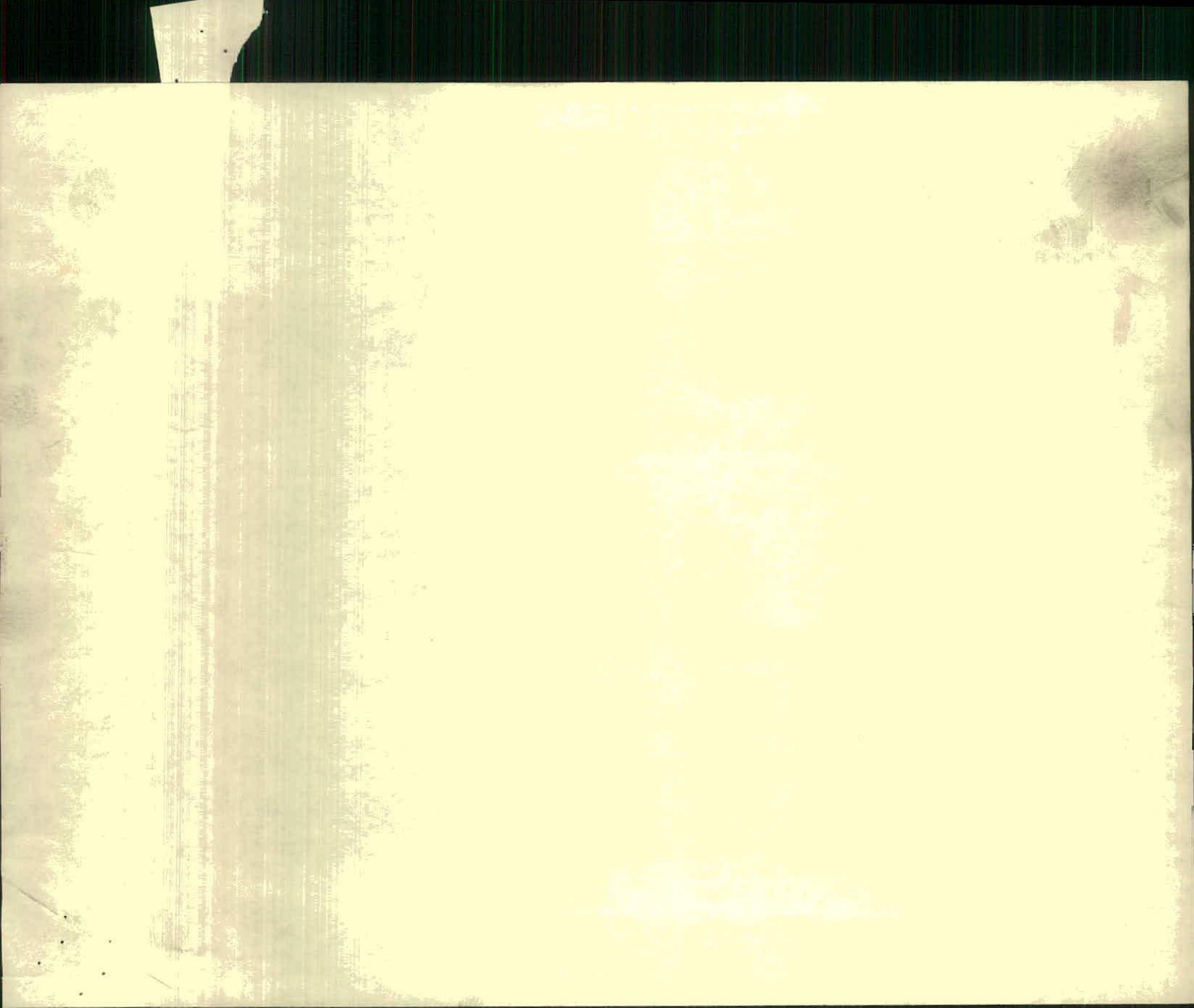
NAS1149D0463J Purchased

No

Each 0.0000

24

12/07/11



Picklist Print

Wednesday, November 09, 2011 11:12:32

Page 2

Work Order ID: 75882
Parent Item: D350-591-121
Parent Item Name: Heli-Access-Step, LH

Start Date: 11/1/2011
Start Qty: 4.00

Required Date: 11/15/2011
Required Qty: 4.00

D2230-1 Manufactured No
Lug

Each 243.0000

1 84135 4 JB

Location	Loc Qty	Loc Code
ST470	94	
72811	94	
ST476	149	
67826	6	
70974	3	
73398	140	

D2230-3 Manufactured No
Lug

Each 143.0000

1 84133 4 JB 12/07/11

Location	Loc Qty	Loc Code
ST476	4	
53881	4	
ST480	139	
70973	1	
73396	18	
74440	120	

D2244-116 Manufactured No
Step Extrusion

Each 89.5000

4 11.11.09

Location	Loc Qty	Loc Code
HALL	89	
60307	89	
WA	0.5	
60307	0.5	

D2582 Manufactured No
Step Leg Assembly

Each 12.0000

4 B72804 (2)
Ac 12.07.09
①

Location	Loc Qty	Loc Code
WA	12	
72739	3	
72828	9	

Shop Packet Print

Wednesday, November 09, 2011 11:12:32 AM

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Picklist Print

Wednesday, November 09, 2011 11:12:33

Page 3

Work Order ID: 75882

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 11/1/2011

Required Date: 11/15/2011

Start Qty: 4.00

Required Qty: 4.00

D2673-34 Manufactured No Each 39.0000

End Plate

4

12.07.03

Location	Loc Qty	Loc Code
WA 884535	19	
69534	19	
WA015	20	
59690	20	

3+3

D2732-030 Rubber Cushion

Manufactured No Each 4.0000

2

8

83560 2B

Location	Loc Qty	Loc Code
ST409	4	
56515	0	
64283	4	

D2850-1 End Bracket

Manufactured No Each 3.0000

4

12.07.03

Location	Loc Qty	Loc Code
WA016	3	
68490	3	

3

D2856-400 Abrasion Strip

Manufactured No f 280.0945

0.24

81875 20

12/07/11

Location	Loc Qty	Loc Code
ST403	0.3149	
68076	0.3149	
ST409	279.7796	
63735	0.6696	
71164	63.11	
73491	216	

Picklist Print

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Page 4

Work Order ID: 75882

Parent Item: D350-591-121

Parent Item Name: Heli-Access-Step, LH

Start Date: 11/1/2011

Required Date: 11/15/2011

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W3

Purchased

No

Each

1,313.0000

64

Cherry Rivets

M 120308 → 26

M 122151 → 38

Ac 12.07.09

Location	Loc Qty	Loc Code
GA	880	
118626	880	
ST321	300	
111636	48	
117505	217	
117601	35	
WA018	133	
107939	133	

MS210421.3

Purchased

No

Each

9,307.0000

8

Nut

2

121444 JB

12/07/11

Location	Loc Qty	Loc Code
ST300	367	
117441	16	
117885	42	
118451	5	
118927	304	
ST516	6000	
119017	6000	
ST518	2940	
119075	2940	

Picklist Print

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Work Order ID: 75882
 Parent Item: D350-591-121
 Parent Item Name: Heli-Access-Step, LH

Start Date: 11/1/2011

Required Date: 11/15/2011

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Nut

Purchased No

Each 12,448.000

3

12

121652

JB

11/10/11

Location

Loc Qty

Loc Code

ST300

1448

117441

51

117601

532

118451

133

118927

732

ST516

6000

119017

6000

ST518

5000

119075

5000

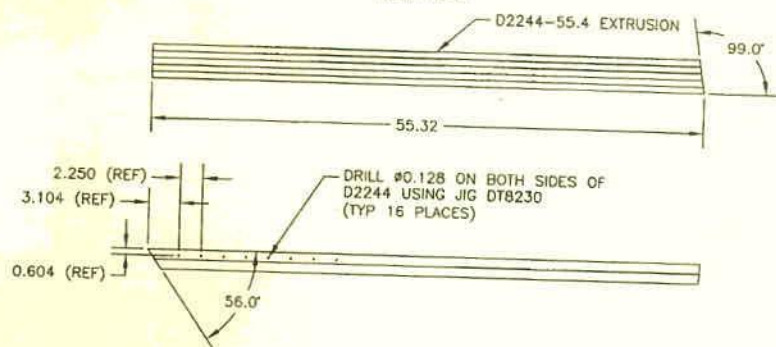
Wednesday, November 09, 2011 11:12:33 AM

Shop Packet Print

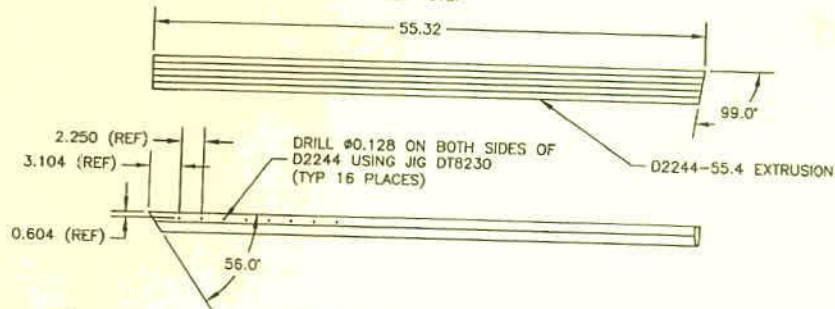
Page 5

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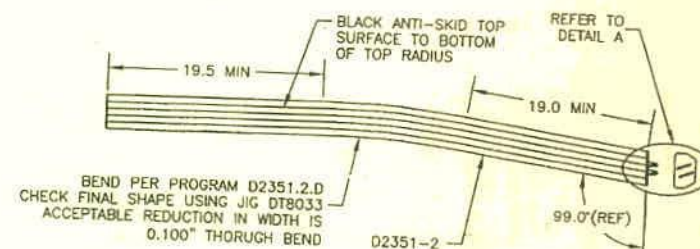
D2351-2 CUTTING/DRILLING DETAIL
RIGHT STEP



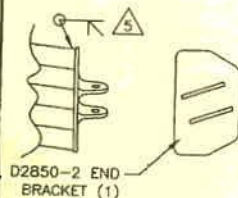
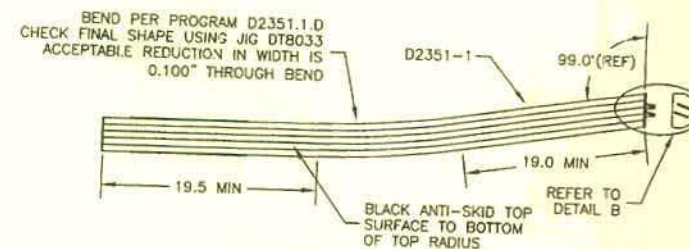
D2351-1 CUTTING/DRILLING DETAIL
LEFT STEP



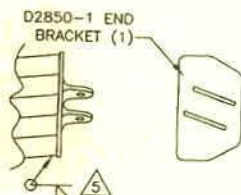
D2351-042 BENDING/ASSEMBLY DETAIL
RIGHT STEP



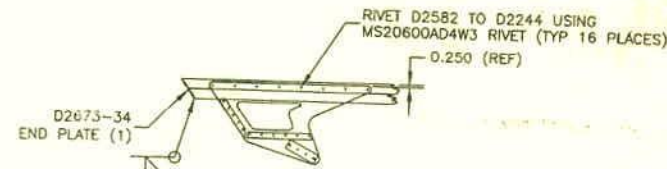
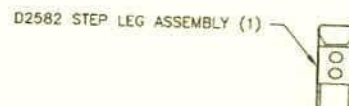
D2351-041 BENDING/ASSEMBLY DETAIL
LEFT STEP



DETAIL A
SCALE: 1:4



DETAIL B
SCALE: 1:4



GENERAL NOTES

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

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DESIGN	KE	DRAWN BY	PH	DART	DART AEROSPACE LTD. UNIONVILLE, ONTARIO, CANADA	REV. E
CHECKED	#	APPROVED	#			
DATE	05.11.14	DRAWING NO.	D2351	SHEET 2 OF 2		SCALE
TITLE			HIGH FLOAT STEP ASSEMBLY			1:12

RELEASED
05.11.28

UNDER REVIEW

03.11.14

DART

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

*cut per drawing

75882 H.C.U.
11/11/01**RELEASED**
05.11.28 #PH
ECN 1105**UNDER REVIEW**07.11.29 #
PER LIC# 263

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5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: G
Date: 08.10.06

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1950

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:


Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.






Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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